

Work Order ID 86108

June-20-12 2:51:41 PM

86108

Page 1

Item ID: D3255-041

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Item Name: Access Panel Assembly

Stop ***NS2***

Start Date: 20/06/2012 Start Qty: 4.00

4

Cust Item ID:

Required Date: 04/07/2012 Req'd Qty: 4.00

4

Customer:

Reference:

Approvals: Process Plan: MLJ

Date: 12/06/2012 Tooling:

Run Start ***NR1***

QC:

Date: SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
----------	--------------

D3255	Rev B
-------	-------

100	Large Fab	0.00
-----	-----------	------

100

Large Fab

Memo

0.00

Large Fab

1-Weld as per Dwg D3255 ***purge weld***A/R SS ROD
Batch: M114509 2-Grind Welds Flush

110	QC10- Inspect visual per QSI004- ground welds	0.00
-----	---	------

110

QC

Memo

0.00

Quality Control

120	QC5- Inspect part completeness to step on W/O	0.00
-----	---	------

120

QC

Memo

0.00

Quality Control

DAS
16
9-83

12/6/12

DAS
16
9-83

12/6/12

12-07-26
18L

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

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Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID Tool # Plan
Code

Accept Reject Reject Insp.
Qty Qty Number Stamp

130

Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3

0.00

130

Powdercoat

Memo

START TIME:

FINISH TIME:

OVEN TEMPERATURE:

Powder Coating

140

QC3- Inspect Part Finish

0.00

140

QC

Memo

0.00

Quality Control

150

Small Fab

0.00

150

Small Fab

Memo

0.00

Small Fab

1-Bond D3255-5 gasaket to d3255-041 using Dow corning adhesive as per Dwg
D3255A/R 736 DOW CORNING ADHESIVE
Batch: 17122346

4X 12/07/31

4 12/08/02

4 12-08-02

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Page 3

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Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

160

QC5- Inspect part completeness to step on W/O

0.00

SMB

16

12/08/07

4

160

QC

Memo

Quality Control

170

Identify as per dwg & Stock Location **ST176** 0.00

170

Packaging

Memo

0.00

Packaging

180

QC21- Final Inspection - Work Order Release

0.00

180

QC

Memo

0.00

Quality Control

4X

12-8-7

12/8/7

MLJ 12/08/07

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Picklist Print

June-20-12 2:51:44 PM

Page 1

Work Order ID: 86108

Parent Item: D3255-041

Parent Item Name: Access Panel Assembly

86108

D3255-041

Start Date: 20/06/2012

Required Date: 04/07/2012

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP Rev:C Removed Manufacturing of D3255-1/-2/-3 06-08-02 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3255-1		Manufactured	No			100	Each	6.0000	1	4			

D3255-1

Panel

**

Location	Loc Qty	Loc Code
WA 86110	4	
83198	4	
WA025	2	
72191	2	

D3255-5

Manufactured No

100 Each 12.0000 1 4

D3255-5

Gasket

**

Location	Loc Qty	Loc Code
GA 86112	12	
72118	1	
75083	1	
83478	10	

D3255-3

Manufactured No

150 Each 6.0000 1 4

D3255-3

Cap

**

Location	Loc Qty	Loc Code
WA	4	
83201	4	
WA022	2	
75969	2	

86109

4

12-07-25
JBL

12-07-25
JBL

(4) 88 12-08-02

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

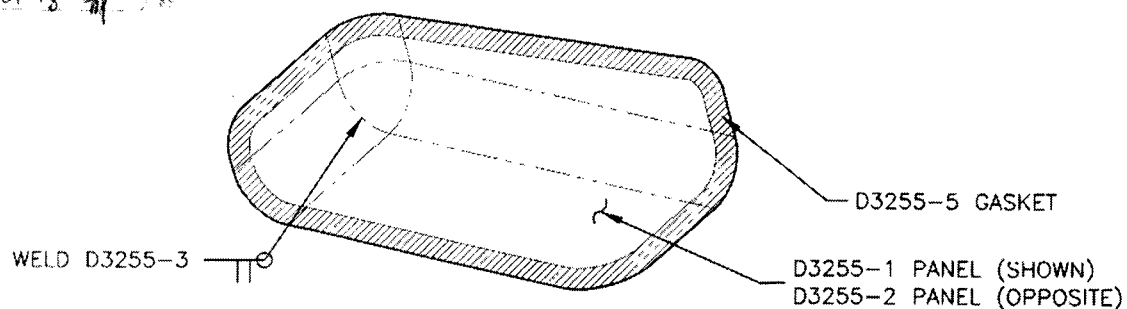
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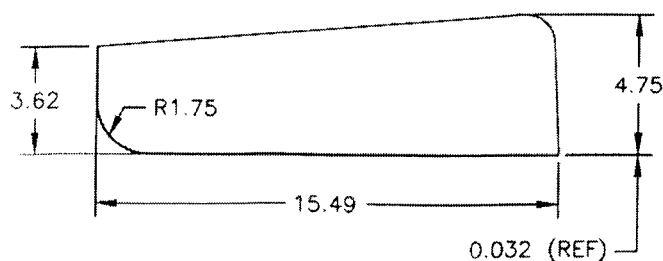
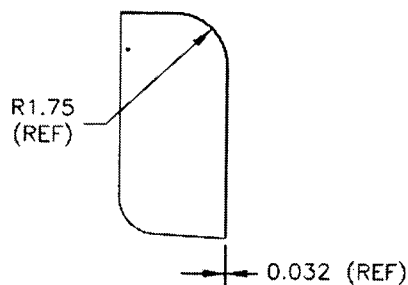
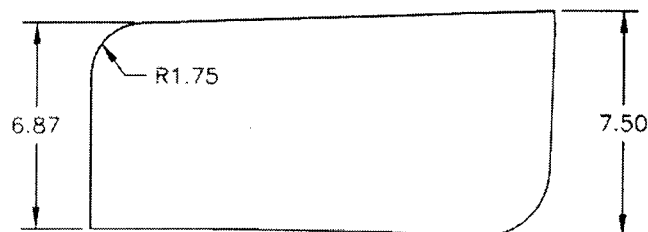


DESIGN RT	DRAWN BY RT	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED if	APPROVED [Signature]	DRAWING NO. D3255	REV. B SHEET 1 OF 4
DATE 04.12.06		TITLE ACCESS PANEL ASSEMBLY	SCALE 1:6
A	04.01.27	NEW ISSUE	
B	04.12.06	D3255-3 REDESIGN; ADDED Ø0.098	

RELEASED
05-01-18 #



D3255-041 ACCESS PANEL (SHOWN)
D3255-042 ACCESS PANEL (OPPOSITE)



D3255-1 BEND DETAIL
D3255-2 OPPOSITE

D3255-041/-042 NOTES:

- 1) WELD PER DART QSI 004
- 2) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER QSI 005 4.3
- 3) INSTALL D3255-5 GASKET USING DOW CORNING P/N 736 ADHESIVE IN ACCORDANCE WITH MANUFACTURE'S INSTRUCTIONS
- 4) IDENTIFY WITH P/N & B/N USING FINE POINT PERMANENT MARKER

SHOP COPY
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WITHOUT NOTICE
WORK ORDER
NO. 261028 MC
12/06/28

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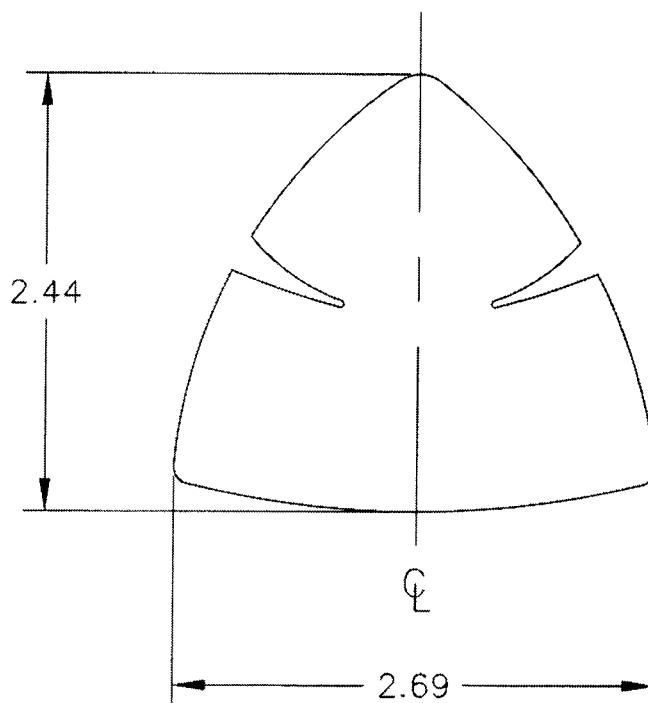
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DESIGN JF	DRAWN BY JF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED JP	APPROVED JF	DRAWING NO. D3255	REV. B SHEET 2 OF 4
DATE 04.12.06		TITLE TITLE	SCALE 1:1

RELEASED
05.01.18 JF



D3255-3 CAP
FORM TO FIT D3155-1/-2

D3255-3 NOTES:

- 1) MATERIAL: AISI 304/316 SS 0.032 THICK (REF. M304S22GA)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 6) MAKE PER DRAWING "D3255-B2.DWG"

2010/08

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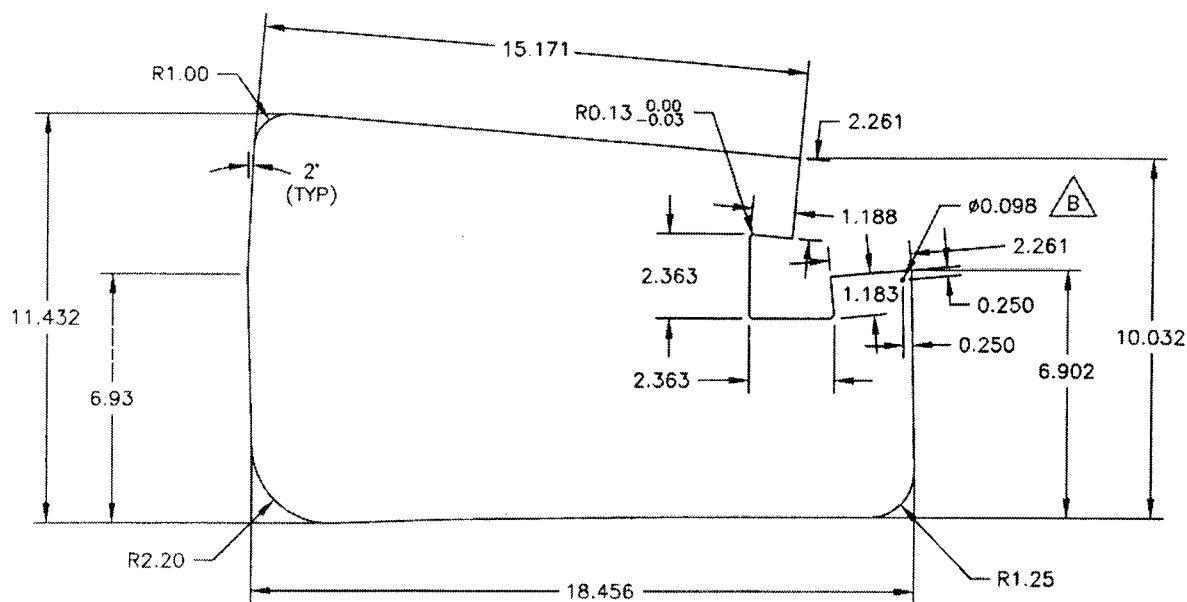
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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DESIGN T.F.	DRAWN BY T.F.	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED ip	APPROVED H	DRAWING NO. D3255	REV. B SHEET 3 OF 4
DATE 04.12.06		TITLE ACCESS PANEL ASSEMBLY	SCALE 1:5



D3255-1/-2 FLAT PATTERN

D3255-1/-2 NOTES:

- 1) MATERIAL: AISI 304/316 SS 0.032 THICK (REF. M304S22GA)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

26108

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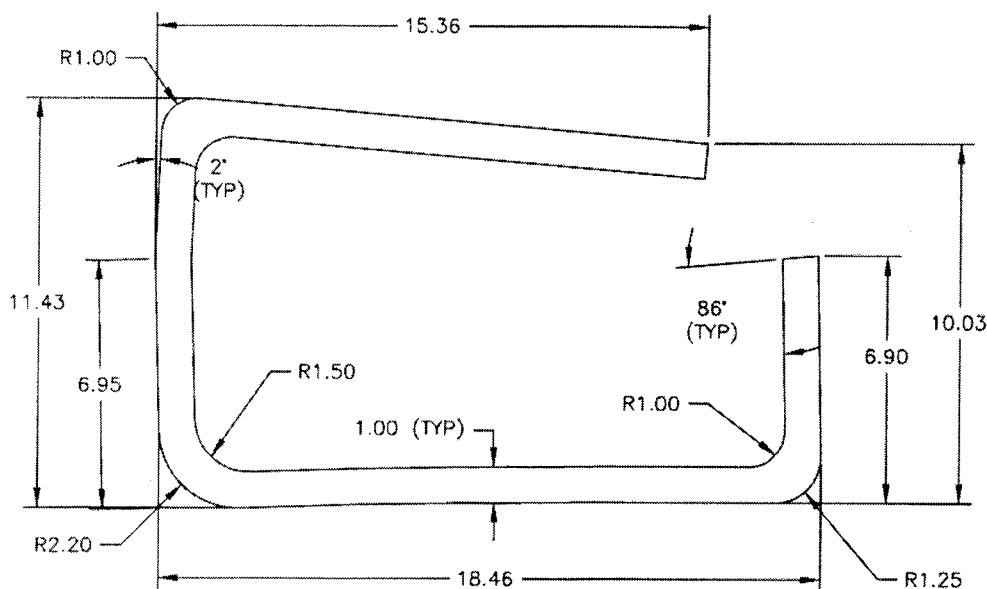
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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DESIGN 77	DRAWN BY 77	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED CP	APPROVED #	DRAWING NO. D3255	REV. B SHEET 4 OF 4
DATE 04.12.06		TITLE ACCESS PANEL ASSEMBLY	SCALE 1:5

RELEASED
05 01 18 #



D3255-5 GASKET

D3255-5 NOTES:

- 1) MATERIAL: SILICONE COATED FIBERGLASS CLOTH PER AMS 3320F
P/N SIL/F 36x36x1/16
POSSIBLE SUPPLIER: AVIALL
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES

20108

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